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## **CLAIMS**

What is claimed is:

1. A method of forming a contact in a flash memory device that improves the depth of focus (DOF) margin and the overlay margin between a plurality of stacked gate layers and the respective contact, comprising the steps of:

forming a plurality of stacked gate layers on a semiconductor substrate, wherein each stacked gate layer extends in a predefined direction and is substantially parallel to other stacked gate layers;

depositing an interlayer insulating layer over the plurality of stacked gate layers;

patterning a contact hole between a first stacked gate layer of the plurality of stacked gate layers and a second stacked gate layer of the plurality of stacked gate layers, wherein the contact hole is an elongated shape; and

depositing a conductive layer in the contact hole.

- 2. The method of claim 1, wherein the step of patterning a contact hole between a first stacked gate layer and a second stacked gate layer includes aligning a major axis of the contact hole substantially parallel to the predefined direction of the stacked gate layers.
- 3. The method of claim 1, wherein the step of patterning a contact hole between a first stacked gate layer and a second stacked gate layer includes aligning a minor axis of the contact hole substantially perpendicular to the predefined direction of the stacked gate layers.
- 4. The method of claim 1, further comprising the step of: removing a portion of the conductive layer that is outside the contact hole to leave the conductive layer in the contact hole.

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5. The method of claim 1, wherein the step of patterning a contact hole between a first stacked gate layer and a second stacked gate layer includes forming a minor axis of the contact hole to be about 71 percent to about 90 percent of a major axis of the contact hole.

- 6. The method of claim 1, wherein the step of patterning a contact hole in an elongated shape includes patterning the contact hole in the shape of an ellipse.
- 7. The method of claim 1, wherein the step of patterning a contact hole in an elongated shape includes patterning the contact hole in the shape of a rectangle.
  - 8. A flash memory device, comprising:

a plurality of stacked gate layers, wherein each stacked gate layer extends in a predefined direction and is substantially parallel to other stacked gate layers; and

a contact formed between a first stacked gate layer of the plurality of stacked gate layers and a second stacked gate layer of the plurality of stacked gate layers, wherein the contact is formed in an elongated shape.

- 9. The flash memory device of claim 8, wherein the contact includes a major axis, and the major axis is substantially parallel to the predefined direction of the stacked gate layers.
- 10. The flash memory device of claim 8, wherein the contact includes a minor axis, and the minor axis is substantially perpendicular to the predefined direction of the stacked gate layers.
- 11. The flash memory device of claim 8, wherein the contact is a  $V_{\rm ss}$  contact.

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12. The flash memory device claim 8, wherein a minor axis of the contact is about 71 percent to about 90 percent of a major axis of the contact.

- 13. The flash memory device of claim 8, wherein the contact hole is in the shape of an ellipse.
- 14. The flash memory device of claim 8, wherein the contact hole is in the shape of a rectangle.